

Date: Thursday, 5/3/2007 11:39:42 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WINDOW SEAL TOOL
Job Number : 32210
Estimate Number : 12558
P.O. Number : N/A Part Number : D35611
This Issue : 5/3/2007 S.O. No. : N/A Drawing Number : D3561 REV.A
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A
Previous Run : 29081 Material : N/A
Written By : Due Date : 5/10/2007 Qty: 20 Um: Each
Checked & Approved By : 07.05.04
Comment : Est:A 06.10.19 New issue EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S11GA 304/316 .125 Sheet



Comment: Qty.: 0.0497 sf(s)/Unit Total: 0.2483 sf(s) 0.9940
304/316 .125 Sheet
Batch: M102817 ml 07 05 07

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3561
Dwg Rev: A
Prog Rev: A
2-Deburr if necessary

ml/SAD 07 05 07

20

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

25

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

07/05/08

20

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

John 07/05/07 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/3/2007 11:39:42 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW SEAL TOOL

Job Number: 32210

Part Number: D35611

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3561

SA 07/05/08

(22)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SA 07/05/08 (20)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

SA 07/05/08 (20)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

SA 07/05/08

Job Completion



SA 07/05/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

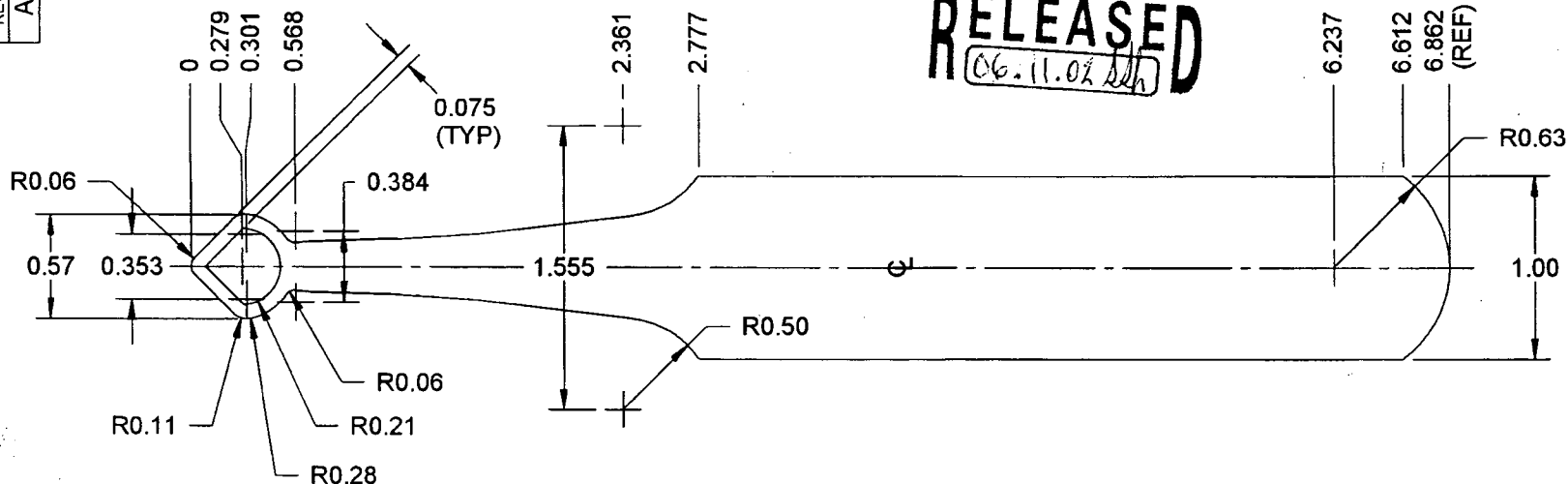
DESIGN		DRAWN BY		DART AEROSPACE LTD	
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA	
DATE		DATE		REV. A	
06.10.06		06.10.06		SHEET 1 OF 1	
06.10.06		06.10.06		SCALE	
06.10.06		06.10.06		1:1	
06.10.06		06.10.06		TITLE	
06.10.06		06.10.06		SEAL INSERT TOOL	
06.10.06		06.10.06		NEW ISSUE	

DART

D3561-1 SEAL INSERT TOOL

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.125 THICK, PER MIL-S-5059 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S10GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP CORNERS 0.015 TO 0.025



D3561-1F SEAL INSERT TOOL FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32210

DART AEROSPACE LTD		Work Order: 32210
Description: Window Seal ^{INSPCT} Tool		Part Number: D3561-1
Inspection Dwg: D3561 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 1.00	+/- 0.030	1.010	✓		Jern	
B 2.777	+/- 0.010	2.777	✓		vern	
C 0.57	+/- 0.030	0.563	✓		vern	
D R0.06	+/- 0.030	R0.06	✓		R-G	
E R0.28	+/- 0.030	R0.28	✓		R-G	
F 0.075	+/- 0.010	0.082	✓		vern	
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: ml. ml	Audited by:	Prototype Approval:	N/A
Date: 07/05/07	Date: 07/05/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	